

Work Order ID 75238

75238

Page 1

October-19-11 1:27:44 PM

Item ID: D4151-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Fwd Hardpoint Assembly, Lower
 Start Date: 19/10/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 07/11/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4151	C								

100 0.00
100
 Small Fab Memo 0.00
 Small Fab 1- Assemble as per dwg

[Signature] 11/10/11 (4)

110 0.00
110
 QC Memo 0.00
 Quality Control

Sub 10125

(4)

120 0.00
120
 Packaging Memo 0.00
 Packaging

Identify as per dwg & Stock Location: 57137

[Signature] 11/14/11 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

11/10/27
ME
11-10-26

W/O:		WORK ORDER CHANGES					
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Picklist Print

October-19-11 1:27:50 PM

Page 1

Work Order ID: 75238

75238

Parent Item: D4151-041

D4151-041

Parent Item Name: Basket Fwd Hardpoint Assembly, Lower

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 4.00

Required Qty: 4.00


Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.07.22 as per revB DD verf:JLM

11.01.21 as per dwg revC DD verf:JLM

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4151-1 *D4151-1* Lower Hardpoint Plate		Manufactured	No			100	Each	8.0000	2	8			
				<u>Location</u>				<u>Loc Qty</u>					
				ST134				8					
					73549			8					
D4151-5 *D4151-5* Fwd Basket Instl Stud		Manufactured	No			100	Each	6.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>					
				ST134				6					
					73546			6					
 AN4C13A *AN4C13A* BOLT		Purchased	No			100	Each	53.0000	2	8			
				<u>Location</u>				<u>Loc Qty</u>					
				ST357				53					
					118451			3					
					118838			50					

**

**

**

8
11/10/25

4
11/10/25

4
8
11/10/25
7
1

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 2

Work Order ID: 75238

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Parent Item: D4151-041

D4151-041

Parent Item Name: Basket Fwd Hardpoint Assembly, Lower

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 4.00

Required Qty: 4.00

MS21043-4

Purchased

No

100

Each

835.0000

2

8

MS21043-4

Nut

**

GB 11/10/25

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

795

117793

295

118686

500

8

NAS1149C0432R

Purchased

No

100

Each

4,722.000

4

16

NAS1149C0432R

Washer

**

GB 11/10/25

Location

Loc Qty

Loc Code

ST297

4722

117291

3722

119124

1000

16

W/O:		WORK ORDER CHANGES					
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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
		X	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
1	2		D4151-1	LOWER HARDPOINT PLATE
2		2	D4151-3	UPPER HARDPOINT PLATE
3	1		D4151-5	FWD BASKET INSTL STUD (LOWER)
4		1	D4151-7	FWD EYEBOLT RECEIVER (UPPER)
5	2	2	AN4C13A	BOLT
6	2	2	MS21043-4	NUT
7	4	4	NAS1149C0432R	WASHER

D4151-043 BASKET FWD HARDPOINT ASSY (UPPER)

D4151-041 BASKET FWD HARDPOINT ASSY (LOWER)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4151-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
 - D4151-041 = 0.88 lbs
 - D4151-043 = 1.17 lbs

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 75238 M.L.J
11/10/19

RELEASED
2011-01-28
MR

C	AN4 HARDWARE WAS AN3 (B6-1, C3-1 & D3-1); Ø0.252 WAS Ø0.191 (C5-2, D1-2); TIGHTENED TOL ON 1.000 DIM (C5-2, D1-2, C7-3, C3-3); Ø0.250 WAS Ø0.191 (C6-3, B4-3); 1.83 WAS 1.76 (C1-2); 2.84 WAS 2.78 (B5-3) AND 1.88 WAS 1.80 (C1-3) TO PRESERVE 1.SED. REASON: SEE D407-787 DESIGN JOURNAL.	MB	10.12.14
B	ADDED D4151-5/-7 (SHT 3); D4151-5 WAS D3911-1 (ZN B6-1 & D3-1); D4151-7 WAS D3911-3 (ZN C4-1 & D3-1) ITEMS #5, 6 & 7 REPLACE MS20815-4M20 (ZN C3-1, D3-1 & B8-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C5-2); Ø0.191 2 PL REPLACES Ø0.129 4 PL (ZN D1-2). REASON: SEE TR-D390-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4151** REV. C
SHEET 1 OF 3

TITLE **BASKET FWD HARDPOINT** SCALE NTS

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W/O:		WORK ORDER CHANGES					
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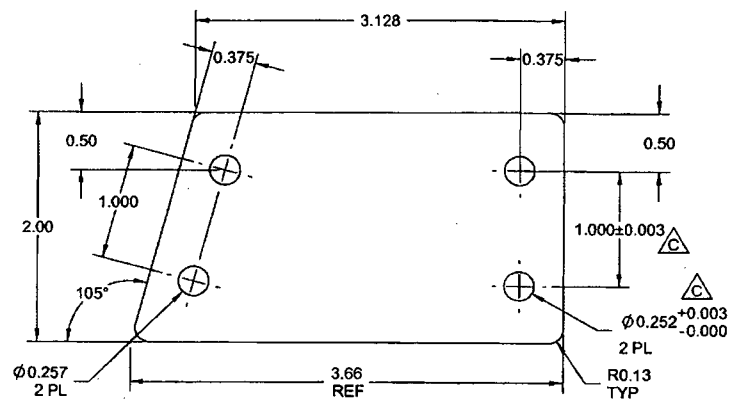
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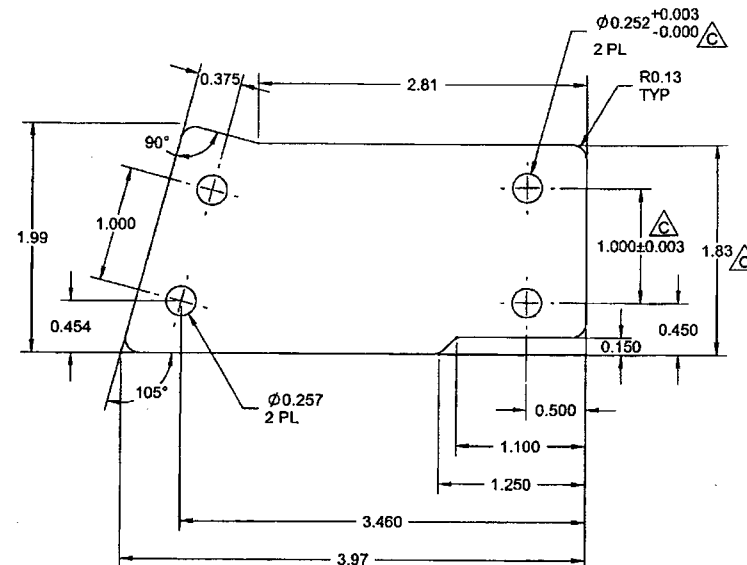
NOTE: Date & initial all entries

75238



0.125
REF

D4151-1 LOWER HARDPOINT PLATE



0.125
REF

D4151-3 UPPER HARDPOINT PLATE

NOTES:

1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S11GA OR M303S11GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY AT ASSEMBLY

7) WEIGHT:

- D4151-1 = 0.24 lbs

- D4151-3 = 0.23 lbs

RELEASED
2011-01-18
MD

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.		D4151	SHEET 2 OF 3
APPROVED	MT	TITLE	SCALE
DE APPR.		BASKET FWD HARDPOINT	NTS
DATE	10.12.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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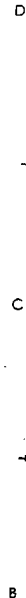
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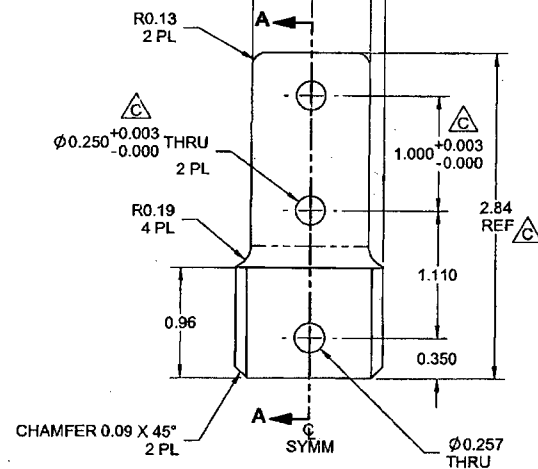
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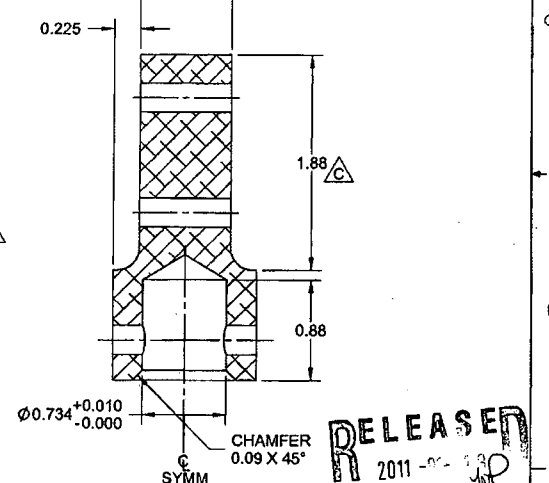
8 7 6 5 4 3 2



3/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
 ER DART SPEC M303R OR M304R
 3/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
 ER DART SPEC M303B OR M304B
 ER DART QSI 018 UNLESS OTHERWISE NOTED
 UNLESS OTHERWISE NOTED
 TOLERANCES: 0.005 TO 0.010 MAX
 IDENTIFY AT ASSEMBLY



DE
DR
CH
MF
AP
DE
DA



	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWING NO.	REV. C
	D4151	SHEET 3 OF 3
	TITLE	SCALE
	BASKET FWD HARDPOINT	NTS
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2011-06-13
RELEASED

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